Monday, 11/12/2007 11:46:41 AM Date: User: Kim Johnston **Process Sheet Drawing Name** : TUBE : CU-DAR001 Dart Helicopters Services Customer Job Number : 35638 **Estimate Number** : 11172 : D22827 Part Number P.O. Number D2282 REV E **Drawing Number** : 11/12/2007 S.O. No. : This Issue : N/A : NC Project Number Prsht Rev. : E : MACHINED PARTS First Issue : // Type **Drawing Revision** : 35474 Material Previous Run Due Date : 11/30/2007 300 Um: Each Written By Checked & Approved By : Est Rev:Á Removed from 9 Digit 05-12-02 JLM Comment **Additional Product** Job Number: Description: Machine Or Operation: Seq. #: 304 RD Tube .675 x .091W 1.0 Comment: Qty.: 20.9790 f(s) 0.0699 f(s)/Unit Total: Material: T304/T316 3/8 Schedule 40, Seamless, Ø0.675" OD, 0.091" wall thickness 22.4" (M304TR0.675W.091) Batch <u>1050</u> 2-3 2.0 HARDINGE HARDINGE CNC LATHE SMALL Comment: HARDINGE CNC LATHE SMALL 1-Turn as per Dwg D2282 and Folio FA190 2-Deburr 3.0 Comment: INSPECT PARTS AS THEY COME OFF MACHINE 4.0 QC8 SECOND CHECK Comment: SECOND CHECK PACKAGING RESOURCE # 5.0 PACKAGING 1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location:

Dart Aerospace Ltd

W/O:		WORK ORDER CH	IANGES			r	
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No		PAR #: Fault Category:	NCR: Yes	No DO	۸٠	Date:	<u> </u>

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
		Description of NC		Corrective Action Section E	3	Verification	Annroval	A	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspecto	
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						1			

NOTE: Date & initial all entries

QA: N/C Closed: ____ Date: ____

Date:

Monday, 11/12/2007 11:46:41 AM

User:

Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TUBE

Job Number: 35638

Part Number: D22827

Job Number:



Comment: FINAL INSPECTION/W/O RELEASE

Seq. #:

Machine Or Operation:

Description:

6.0

QC21

FINAL INSPECTION/W/O RELEASE





Job Completion



Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES									
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Part No:	PAR #:	Fault Category:	NCR: Yes No	DQA:	Date:
			QA: N/C (losed:	Date:

	WORK ORDER NON-CONFORMANCE (NCR)								
	Description of NC		Corrective Action Section B		Verification	Approval	Approval		
STEP	Section A	Initial Chief Eng	Initial Action Description Sign &		Section C Chief Eng		QC Inspector		
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	35638
Description: Handle Tube	Part Number:	D2282-7
Inspection Dwg: D2282 Rev: E		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.795	+/-0.010	,793	/			
0.493	+/-0.010	.489	~			
0.675	+/-0.010	.677	/			
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Measured by:	Audited by: J.F.	Prototype Approval:	N/A
Date: 07/01/13/	Date: 07/1/13	Date:	N/Ą

Rev	Date	Change	Revised by	Approved
Α	03.11.11	New Issue P/O D350-615-041	KJ/RF	
В	05.04.19	0.795 was 0.750	KJ/JLM	
С	06.03.15	Dwg Rev update	KJ/JLM	
D	07.07.17	Dimensions added per Dwg Rev. E	KJ/JLM	Æ
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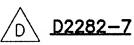
DESIGN BW		DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECK	KED . O	APPROVED	DRAWING NO. REV. E
	a	1000	D2282 SHEET 1 OF 2
DATE			TITLE SCALE
05.0	06.07		HANDLE TUBES 1:1
Α		94.10.14	NEW ISSUE
В		95.03.23	RE-DESIGN
С		97.10.20	CORRECTED NUMBERING SCHEME
D		05.03.16	REDESIGN D2282-5; 0.795 WAS 0.750
E		05.06.07	D2282-5 304 SS WAS 303 SS; R0.063 x 0.063 WAS R0.080 x 0.030



2.375_0.000	0.795

Ø0.675 (REF) Ø0.493 (REF)

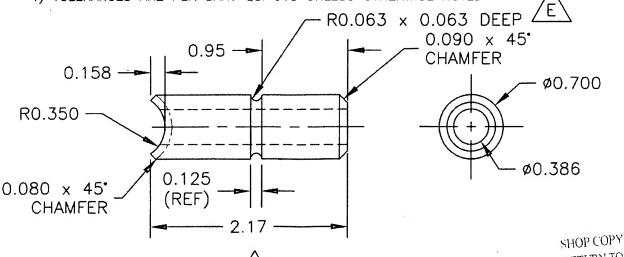
D2282-3



D2282-3/-7 TUBE:

- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W.091)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES

4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D2282-5 STEM:

- 1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RETURN TO ENGINEERING UNGONTROLLED COI

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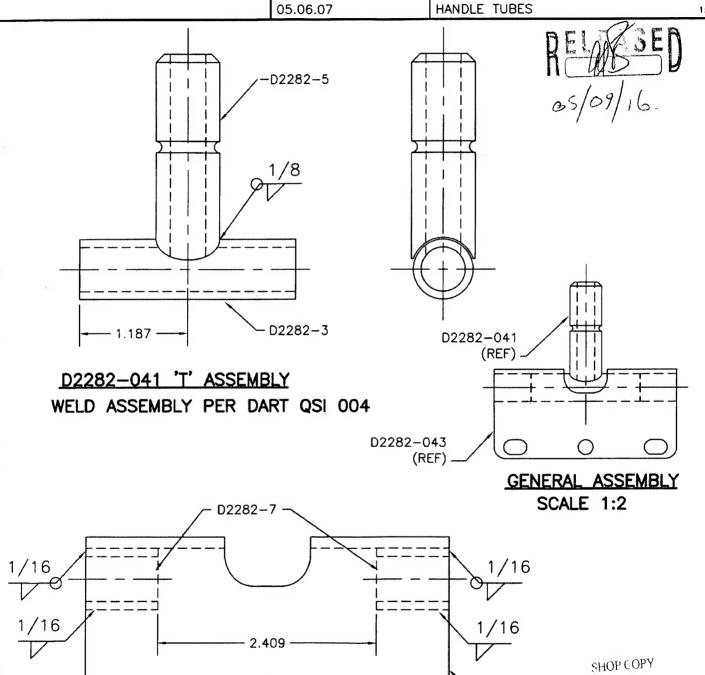
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D2282-5

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DESIGN DRAWN BY		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. E
l u	larb	D2282	SHEET 2 OF 2
DATE	1 000	TITLE	SCALE
05.06.07		HANDLE TUBES	1:1



D2282-043 SADDLE ASSEMBLY WELD ASSEMBLY PER DART QSI 004

RETURN TO ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE

D2281

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